

Work Order ID 85306

85306

Page 1

June-05-12 3:33:51 PM

Item ID: D3703-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Corner Doubler

Start Date: 05/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/05* Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3703

Rev A

(3)

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3703Dwg Rev: *A* Prog

Rev: *A* 2- Debur if necessary

6061 .063"

1812-6-12

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

1812-6-12

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Sale 12

(43)

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

3 76 12-6-12

140 QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

Sr/local13

(x3)

150 Identify as per dwg & Stock Location ST19C

0.00

150

Packaging

Memo

0.00

Packaging

3

Suc 12/06/13

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

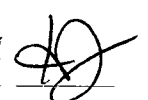
160

QC

Memo

0.00

Quality Control

12/6/14 
ML512/06113

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June-05-12 3:33:55 PM

Page 1

85306

D3703-3

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-04-24 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No				sf	606.9122		2.38	6		

M6061T6S 06.3

6061-T6 .063 Sheet

HR12-67

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT021	606.9122000	
113608	0	
116308	6.01556842	
117285	67.544	
119331	44.2	
119802	15.94	119802
120218	19.34	
120866	66.6026316	
121805	387.27	

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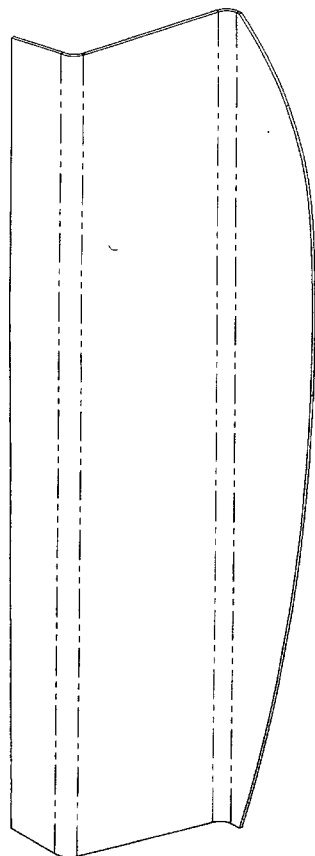
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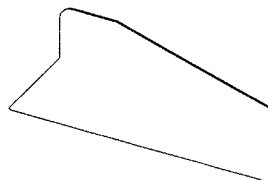
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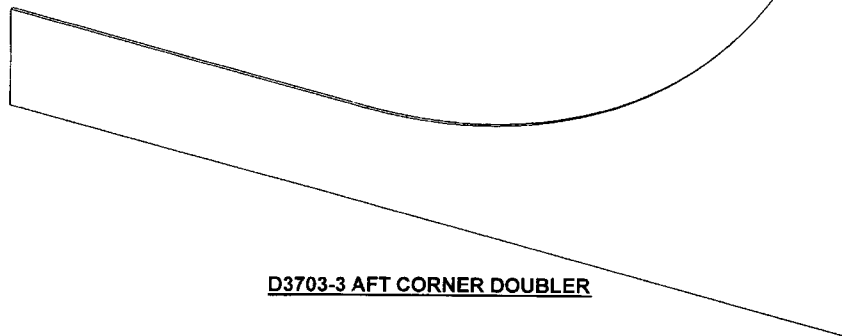
NOTE: Date & initial all entries



8 D3703-1 AFT DOUBLER



D3703-5 AFT CAP



D3703-3 AFT CORNER DOUBLER

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3703-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3703-1 = 0.56 lbs
D3703-3 = 0.23 lbs
D3703-5 = 0.03 lbs
- 8) MANUFACTURE PART FROM "D3703-1F.DXF" FILE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 85306 MLJ

12/06/05

RELEASED
09/04/09

A	NEW ISSUE	MB	08.04.30
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.04.30		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3703	REV. A
TITLE AFT DOUBLER	SCALE NTS
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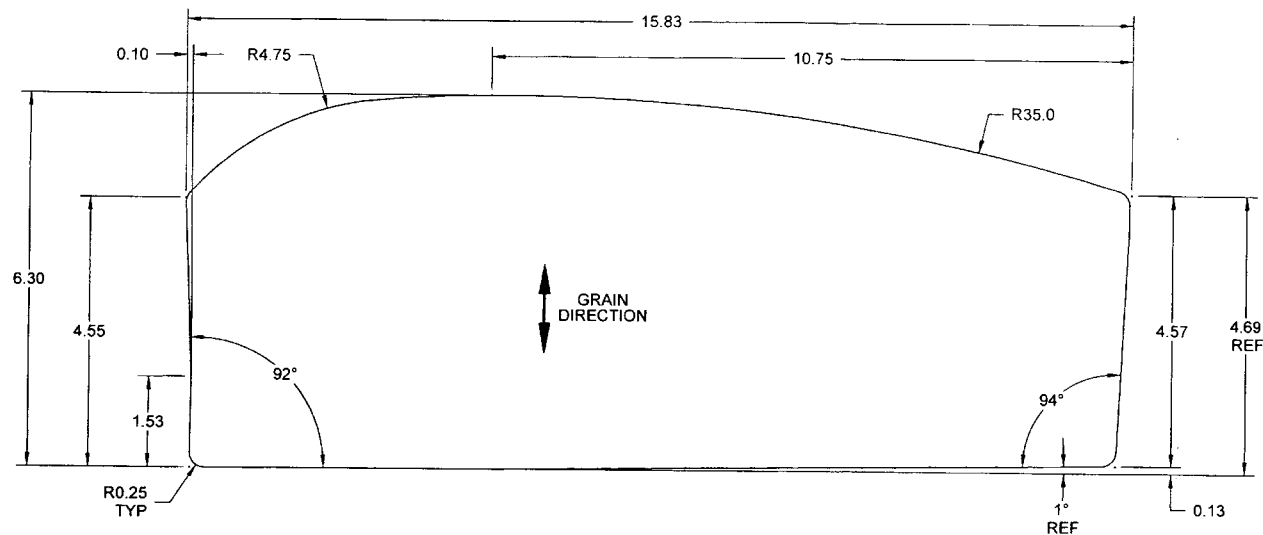
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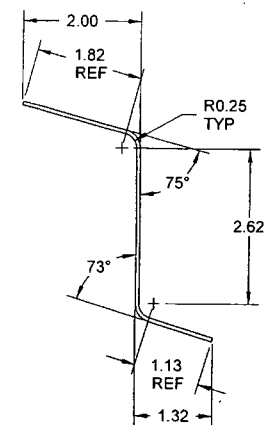
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NOTE: Date & initial all entries

25306



D3703-1F AFT DOUBLER FLAT PATTERN



**D3703-1 AFT DOUBLER
(MAKE FROM D3703-1F)**

RELEASED
09/04/09

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3703	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		AFT DOUBLER	NTS
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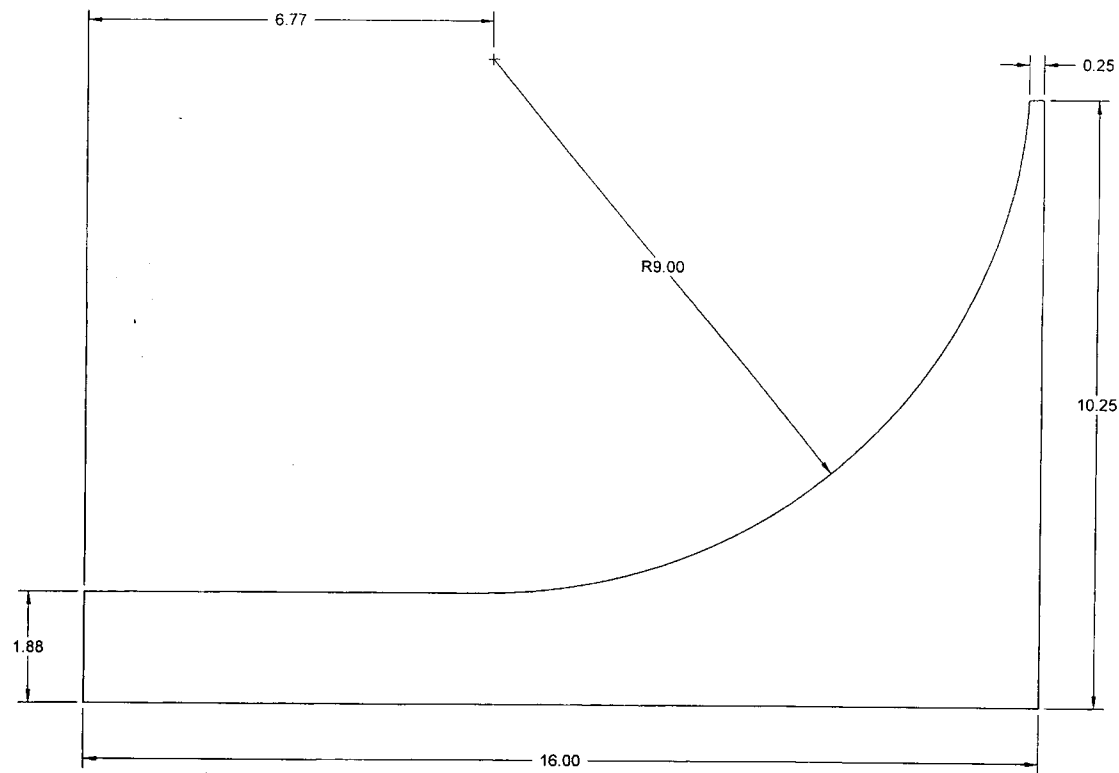
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95306



D3703-3 AFT CORNER DOUBLER

RELEASED
07/04/09 NP

DESIGN	15	DART AEROSPACE LTD	
DRAWN	3	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PT	DRAWING NO.	REV. A
MFG. APPR.	10	D3703	SHEET 3 OF 4
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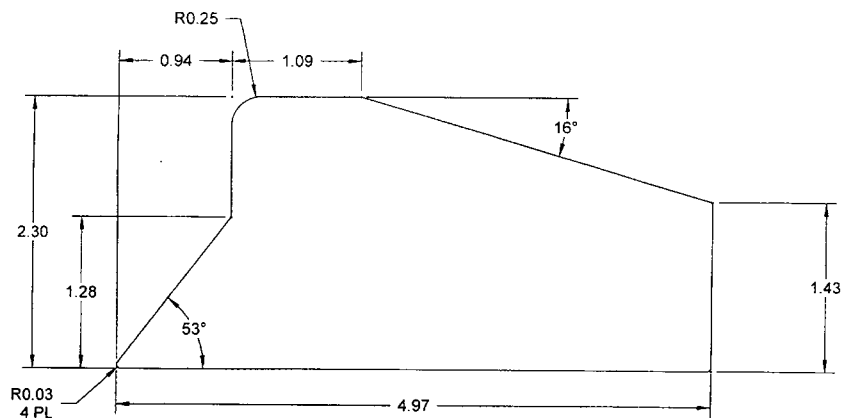
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
NOTE: Date & initial all entries

05306



D3703-5 AFT CAP

RELEASED
09/04/09

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CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D3703	SHEET 4 OF 4
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